

Date: Monday, 22/09/2008 10:13:37 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|---------------------------------------|-------------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : ACCESS PANEL |
| Job Number | : 42146 | | |
| Estimate Number | : 12500 | | |
| P.O. Number | : | Part Number | : D32551 |
| This Issue | : 22/09/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3255 REV B |
| First Issue | : 22/09/2008 | Project Number | : N/A |
| Previous Run | : 37464 | Drawing Revision | : B |
| | Type : SMALL /MED FAB | Material | : |
| Written By | : | Due Date | : 30/09/2008 |
| Checked & Approved By | : <u>JLU 08.9.22</u> | Qty: | 4 |
| Comment | : Est Rev:A New Issue 06-08-01 JLM | Um: | Each |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S22GA | 304/316 .032 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 1.5582 sf(s)/Unit Total : 6.2328 sf(s)
 304/316 .032 Sheet
 (M304S032)
 Batch: 109057 HB 8-9-22

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3255
 Dwg Rev: B
 Prog Rev: B

HB 8-9-22

(4)

2-Deburr if necessary HB 8-9-22

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-9-22

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

S 08/09/22 (4)

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
 Form as per Dwg D3255

EF 08/10/06

(4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 10:13:37 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL

Job Number: 42146

Part Number: D32551

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/06 (X4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

lpc 08.10.06

(X4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.10.07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

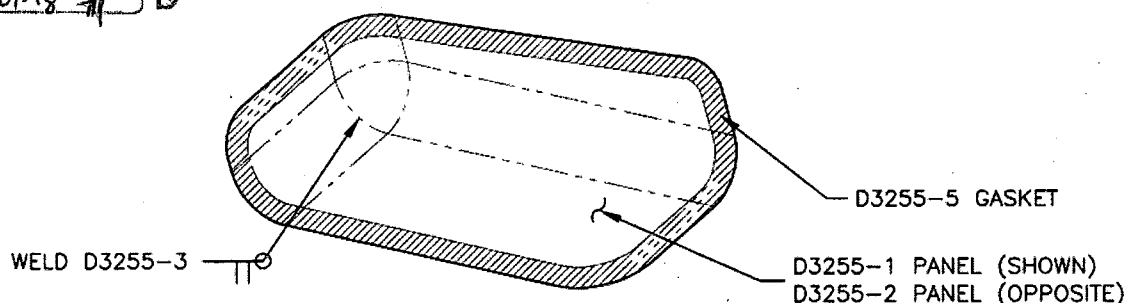
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

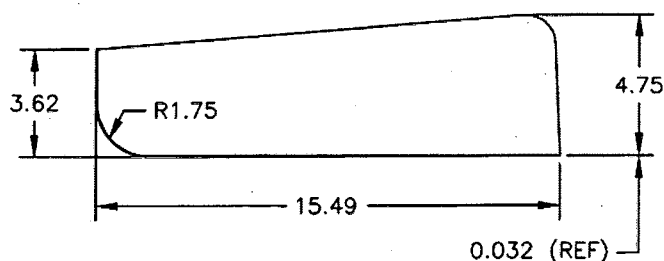
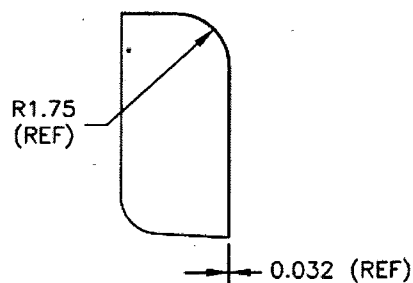
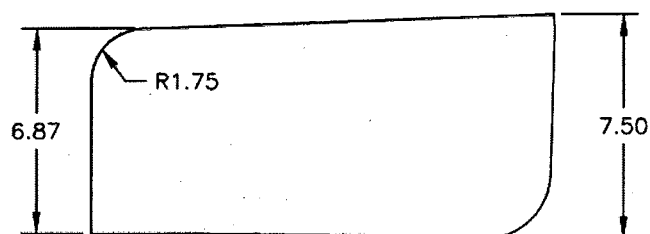


| | | | |
|------------------|-------------------------|---|------------------------|
| DESIGN F# | DRAWN BY F# | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED up | APPROVED [Signature] | DRAWING NO. D3255 | REV. B SHEET 1 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:6 |
| A | 04.01.27 | NEW ISSUE | |
| B | 04.12.06 | D3255-3 REDESIGN; ADDED ϕ 0.098 | |

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 42146

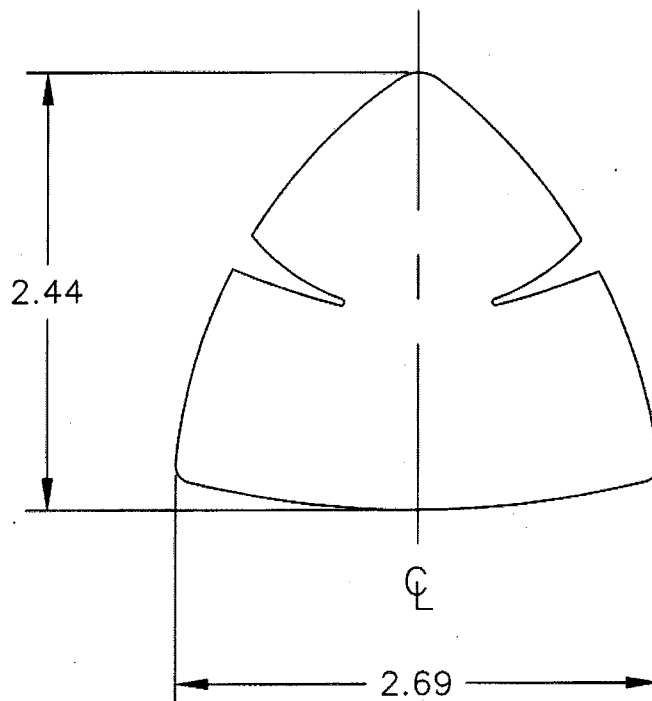
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| CHECKED 9P | APPROVED [Signature] | DRAWING NO. D3255 | REV. B SHEET 2 OF 4 |
| DATE 04.12.06 | | TITLE TITLE | SCALE 1:1 |

RELEASED
05-01-18 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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NO. 42196

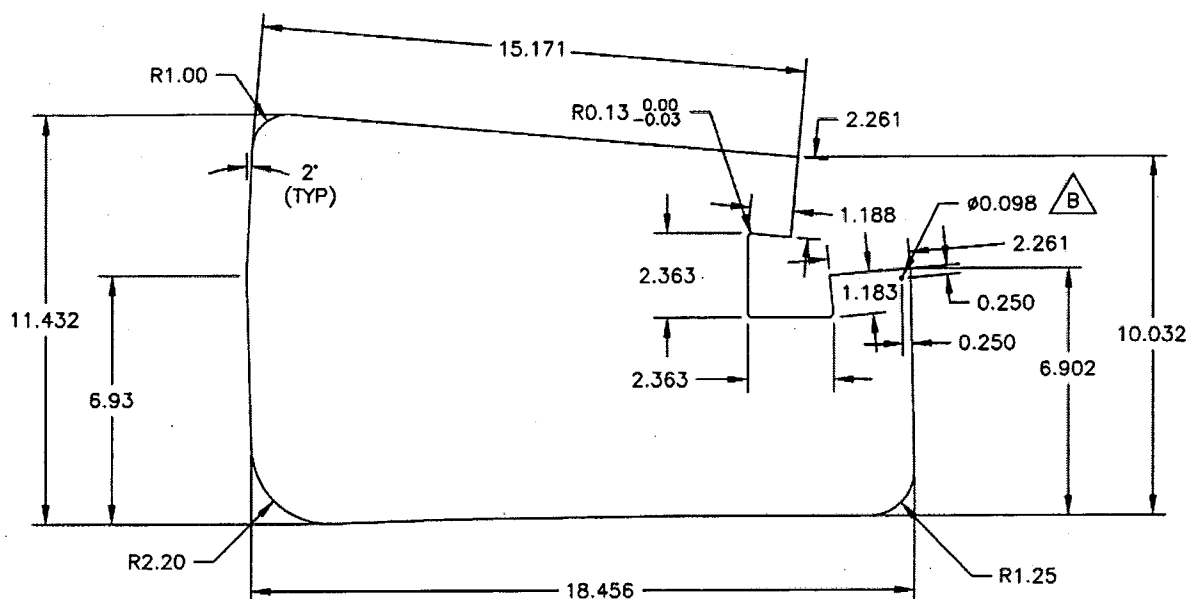
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| CHECKED CP | APPROVED RF | DRAWING NO. D3255 | REV. B SHEET 3 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 |

RELEASED
05-01.18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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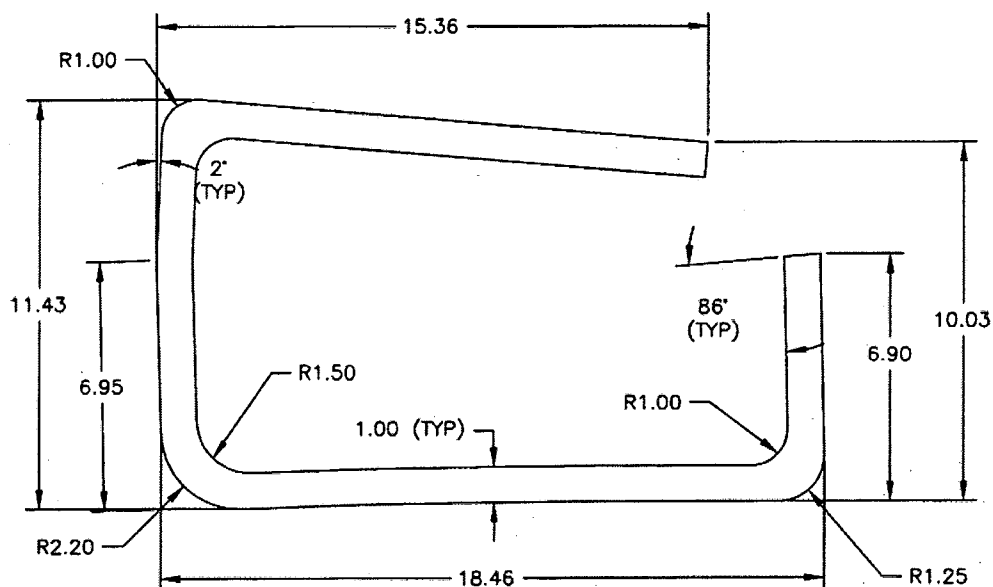
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| CHECKED 4P | APPROVED 77 | DRAWING NO. D3255 | REV. B SHEET 4 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 |

RELEASED
05-01-18 #



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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